



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3130-70-101-5

Job Sheet 185271



Part No: RBW109-3130-70-101-5

Job Qty: 4 ea *5 ea 21 9-89*

Part Name: Barrel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-70-101 Rev.2 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		<i>DAS 11-22</i>
110	CNC Lathe	4 pcs	11/9/18	11/9/18	0.00	2.00	MORI SL2500Y		<i>56 11-22</i>
120	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		<i>9-89 11-22</i>
130	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		<i>18-11-23</i>
150	Outsource	4 pcs	11/9/18	11/9/18	0.00	0.00	Outsource4 (ATG)		<i>18-11-26</i>
160	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		<i>NOV 27 2018</i>
170	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC6		<i>21 38</i>
180	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		<i>21 38</i>
190	QC21-SA	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		<i>21 38</i>

Part Op 110 - 1-Machine as per DWG. FC _____ FOLIO REV: *AT* DWG REV: *2* 2-Debur
Descriptions: 130 - Engrave RBW109-3130-70-105 and RBW109-3130-70-111 using MARKTRONIC engraver as per DWG.
150 - Issue P/O to GROUPE ALTECH; PO *41851* -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
CLASS 1, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.250	6061-T6 Round Bar 3.250"	.8880 ft (.222 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R3.250	1	13	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

found.

Plex 10/24/18 12:33 PM Dart.lajeunesse.marie

Container No: S130635



Part: RBW109-3130-70-101-5

Job No: 185271

Serial No/Batch: S130635

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 11/22/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

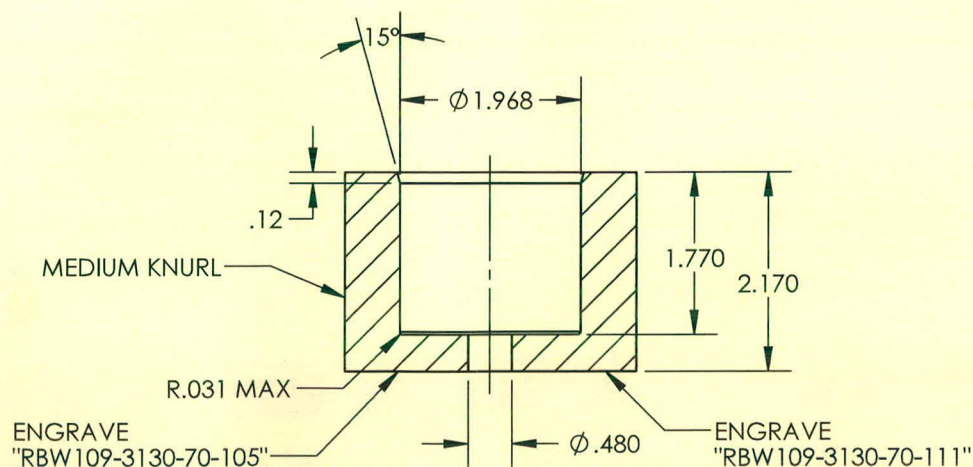
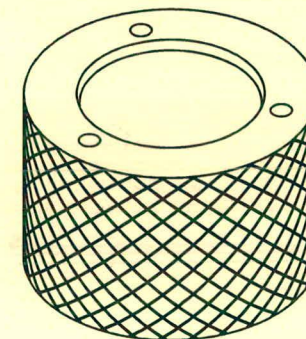
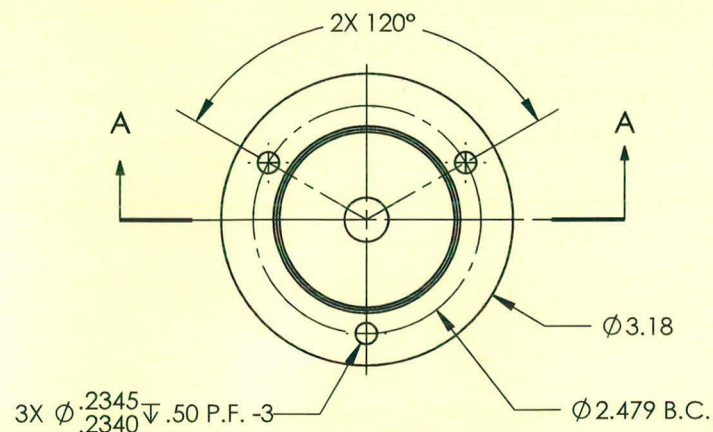
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	-5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX, ADDED ENGRAVE "RBW109-3130-70-111"	4/17/2014	RJC
			DW



SECTION A-A

(-5)

BARREL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185271 MGS

187024

RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101-5	REV 2
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:2	DATE 4/4/2011
SHEET 4 OF 5	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041851**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041851

PO Date: 11/26/18

Due Date: 12/11/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: ** Please confirm dates as per line ** :)

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185269	RBW109-3130-70-101-7	Base -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	12/4/18	4 pcs	0 pcs	4 pcs	\$11.00/pcs	\$44.00
Line Item Note ** ASAP **											
2	185760	646.3210	Support Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	12/4/18	10 pcs	0 pcs	10 pcs	\$20.35/pcs	\$203.50
3	186020	649.5010	Deflector Issue P/O to ATG: HARD ANODIZE COLOR BLACK,AND PRIME AS PER DWG 649.5000 REV. D	Firmed	-	12/11/18	1 pcs	0 pcs	1 pcs	\$40.00/pcs	\$40.00
	186828			Firmed	-	12/11/18	1 pcs	0 pcs	1 pcs	\$40.00/pcs	\$40.00
Sub Total:							2	0	2		\$80.00



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PURCHASE ORDER **PO041851**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186019	649.5214	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N	Firmed	-	12/11/18	4 pcs	0 pcs	4 pcs	\$15.00/pcs	\$60.00
5	185271	RBW109- 3130-70- 101-5	Barrel -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	12/11/18	5 pcs	0 pcs	5 pcs	\$11.00/pcs	\$55.00
Grand Total:										\$442.50	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/27/18 12:59 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916624

Date: 27-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: RBW109-3130-70-101-7 Base Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Job: 24218	Rev: 2 PO: PO041851 Line: 1	
5 ea	Part: RBW109-3130-70-101-5 Barrel Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Job: 24222	Rev: 2 PO: PO041851 Line: 6	DAS 38 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>27/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

